



Dart Aerospace Ltd.  
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Canada

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D3650-3

Job Sheet 183370



Part No: D3650-3

Job Qty: 2 ea

Part Name: Center Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 9/28/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-09-27 DD verified by: EC IPP Rev:B ECN 1113P 08-01-22 DD IPP  
REV:C AS PER REV E 12-10-09 JLM VERIFIED BY:DD IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 2 Ea  | 9/28/18    | 9/28/18  | 0.00      | 0.00    | Start Up Waterjet     |           | SC 18/09/20    |
| 100   | Waterjet           | 2 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.44    | Waterjet1             |           | SC 18/09/20    |
| 110   | QC                 | 2 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC2 Waterjet-2        |           | SC 18/09/20    |
| 120   | QC                 | 2 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC8-3                 |           | SEP 21 2018 68 |
| 130   | Brake NC           | 2 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.99    | Brake NC 1            |           | DAS 9-89       |
| 140   | QC                 | 2 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC5                   |           | JAN 11 2019 68 |
| 190   | Packaging          | 2 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | Packaging3            | 5+233     | 9-89 DAS       |
| 200   | QC21-SA            | 2 Ea  | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC21                  |           | DAS 6 9-89     |

Part Op 100 - 1-Cut as per Dwg D3650 Dwg Rev: E Prog Rev: E 2-Deburr if necessary  
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB  
 120 - QC8- Inspect parts - second check  
 130 - 1-Form as per Dwg D3650 using DT9426 2-bend as per dwg  
 140 - QC5- Inspect part completeness to step on W/O  
 190 - Identify as per dwg & Stock Location:  
 200 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item | Component Name     | Quantity            | Operation             | Container |
|-------------|--------------------|---------------------|-----------------------|-----------|
| M304S20GA   | 304/316 .040 Sheet | 2.5000 sf (1.25 ea) | 90-Start up Operation | 5090402   |

## Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M304S20GA      | 3        | 291       | 0         |

## Part Specifications

Specifications could not be found.

Plex 9/17/18 10:20 AM Dart.Gagnon.Michelle



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**Container No: S112155**



**Part: D3650-3**

**Job No: 183370**

**Serial No/Batch: S112155**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 09/20/18**

|                                  |               |                             |
|----------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>        |               | <b>Work Order:</b> 183370   |
| <b>Description:</b> Center Panel |               | <b>Part Number:</b> D3650-3 |
| <b>Inspection Dwg:</b> D3650     | <b>Rev:</b> E | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.276             | +/-0.010  | 0,284            | 1      |        | VSC-01               |          |
| 0.213             | +/-0.010  | 0,220            | 1      |        | Type                 |          |
| 0.400             | +/-0.010  | 0,404            | 1      |        |                      |          |
| 0.85              | +/-0.030  | 0,856            | 1      |        |                      |          |
| 12.900            | +/-0.010  | 12,900           | 1      |        |                      |          |
| 4.300             | +/-0.010  | 4,306            | 1      |        |                      |          |
| 13.750            | +/-0.010  | 13,750           | 1      |        |                      |          |
| 15.46             | +/-0.030  | 15,46            | 1      |        |                      |          |
| 1.947             | +/-0.010  | 1,950            | 1      |        |                      |          |
| 5.894             | +/-0.010  | 5,899            | 1      |        |                      |          |
| 8.267             | +/-0.010  | 8,270            | 1      |        |                      |          |
| 9.187             | +/-0.010  | 9,190            | 1      |        |                      |          |
| 15.53             | +/-0.030  | 15,53            | 1      |        |                      |          |
| 13.80             | +/-0.030  | 13,80            | 1      |        |                      |          |
| 2.286             | +/-0.010  | 2,290            | 1      |        |                      |          |
| 7.190             | +/-0.010  | 7,194            | 1      |        |                      |          |
| 9.570             | +/-0.010  | 9,578            | 1      |        |                      |          |
| 10.650            | +/-0.010  | 10,650           | 1      |        |                      |          |
| 12.097            | +/-0.010  | 12,099           | 1      |        |                      |          |
| 10.509            | +/-0.010  | 10,505           | 1      |        |                      |          |
| 0.040             | +/-0.010  | 0,036            | 1      |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |

|                        |                    |                              |
|------------------------|--------------------|------------------------------|
| <b>Measured by:</b> SC | <b>Audited by:</b> | <b>Preliminary Approval:</b> |
| <b>Date:</b> 18/09/20  | <b>Date:</b>       | <b>Date:</b>                 |

| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A   | 08.04.17 | New Issue                        | KJ/DD      |          |
| B   | 12.03.08 | Dwg Rev updated                  | KJ         |          |
| C   | 12.09.26 | Dimensions updated per Dwg Rev D | KJ         |          |
| D   | 12.10.26 | Dimensions updated per Dwg Rev E | KJ         |          |